

Date: Monday, 18/08/2008 10:26:42 AM  
User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BASKET LID ASSEMBLY		
Job Number	: 41286A			Part Number	: D3325041		
Estimate Number	: 10853			Drawing Number	: D3325 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 18/08/2008 S.O. No. :			Drawing Revision	: B		
Prsh Rev.	: NC			Material	:		
First Issue	: / / Type : LARGE FAB ASSY			Due Date	: 08/09/2008 Qty: 1 Um: Each		
Previous Run	: 41171A						
Written By	:						
Checked & Approved By	: <u>JUL 08-8-18</u>						
Comment	: Est Rev:A 05.02.09 New issue KJ/JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D33281	Basket Hinge	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
		2 D3328-1 Hinge Plate <u>333871</u>	<u>PCL 08-09-00</u>
2.0	D33491	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
		2 D3349-1 Spacer Bushing <u>B34205</u>	<u>PCL 08-09-10</u>
3.0	D33521	Label Plate	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
		2 D3352-1 Label Plate <u>B41925</u>	<u>PCL 08-09-11</u>
4.0	D33671	Mounting Bracket	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
		2 D3367-1 Mounting Bracket <u>B40775</u>	<u>PCL 08-09-10</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BASKET LID ASSEMBLY

Job Number: 41286A

Part Number: D3325041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0 M4130NTS0500W035

4130 Square tube .500 x .500 x .035w



Comment: Qty.: 21.5687 f(s)/Unit Total : 21.5687 f(s)

Material: 4130 Cond. N Square tube per MIL-T-6736,  
1/2" x 0.035" wall  
M4130N-TS0.500W.035)

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



PL 08-09-10



Comment: LARGE FABRICATION RESOURCE 1

1-Cut tubes as per Dwg D3325

Qty	Part Number	Description	Batch
2	D3325-1	EndTube	
3	D3325-3	Interior Tube	M104185
2	D3325-5	Full Length Tube	

Identify parts appropriately

2-Remove all markings from material

3-Drill and Weld as per Dwg D3325 & QSI 004  
A/R4130 Steel Rod M102226

4-Deburr as required

7.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PL 08-09-11 (1)

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

(2) 08-09-11 (1)

9.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT

START TIME: 11:45am

OVEN TEMPERATURE: 400°F

12:15pm

9/1

08-09-11

(X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 10:26:42 AM  
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## Process Sheet

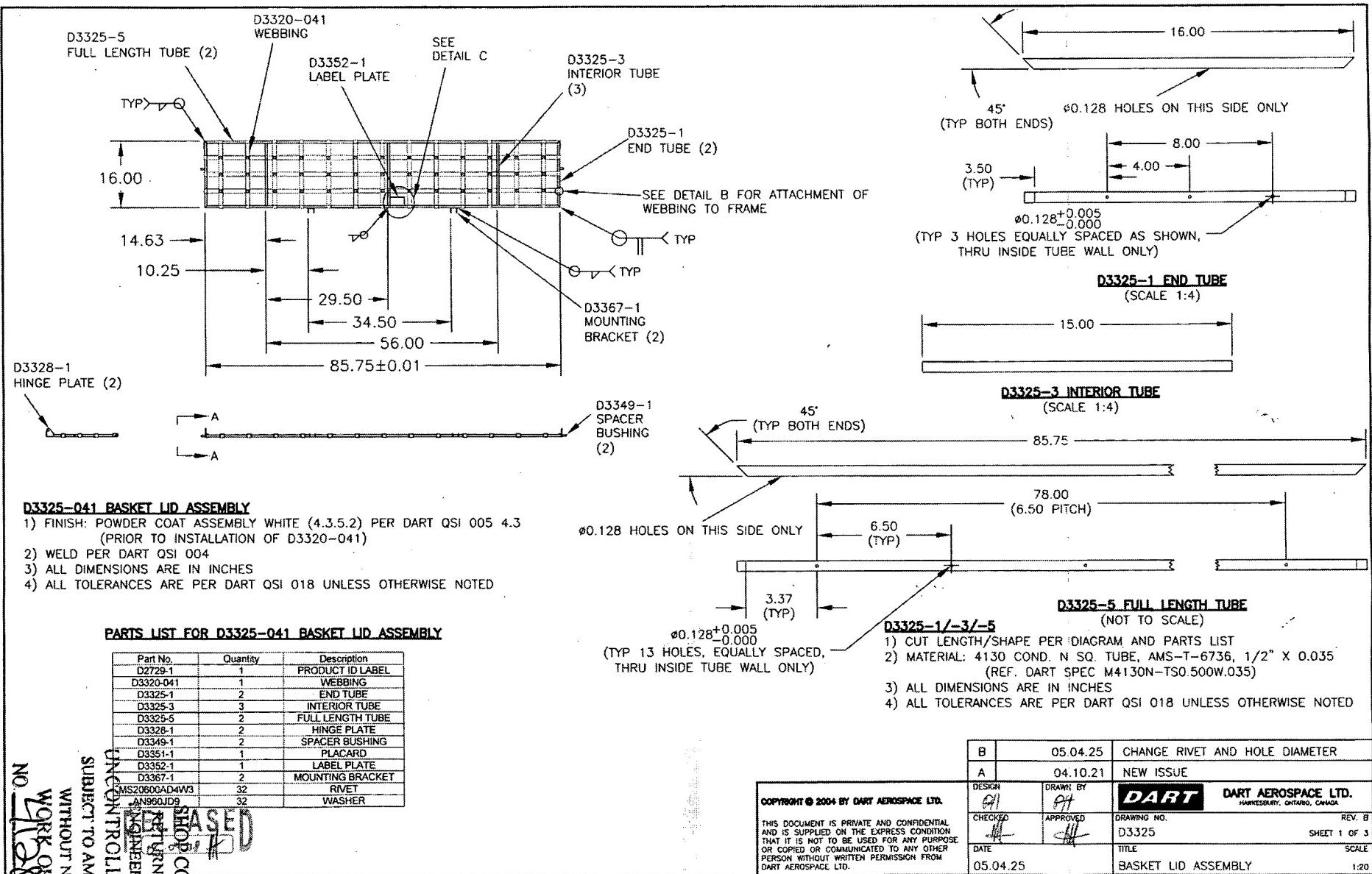
Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: BASKET LID ASSEMBLY
Job Number: 41286A		Part Number: D3325041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
	FINISH TIME: <u>12:15pm</u>	M108523
	2ND COAT:	
	START TIME: <u>12:50pm</u>	
	OVEN TEMPERATURE: <u>400°p</u>	
	FINISH TIME: <u>1:20pm</u>	<u>JH 08-09-11</u> <u>(X)</u>
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
11.0	PACKAGING 1	PACKAGING RESOURCE #1 
12.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION <u>EP 08/09/12 Q</u>		
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>6-A</u> <u>EP 08/09/12 Q</u>		
Comment: FINAL INSPECTION/W/O RELEASE <u>08/09/12 X</u>		
Job Completion		 <u>MF 08-09-12</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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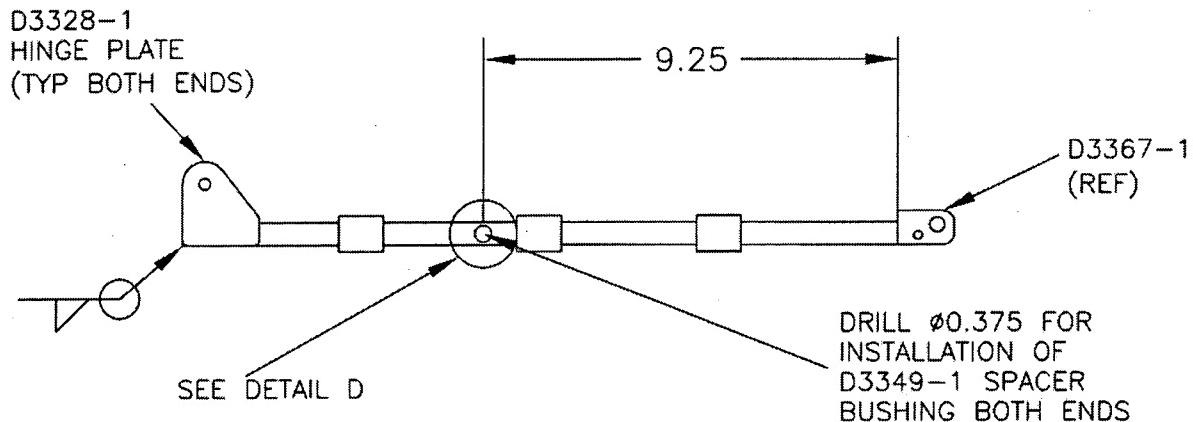
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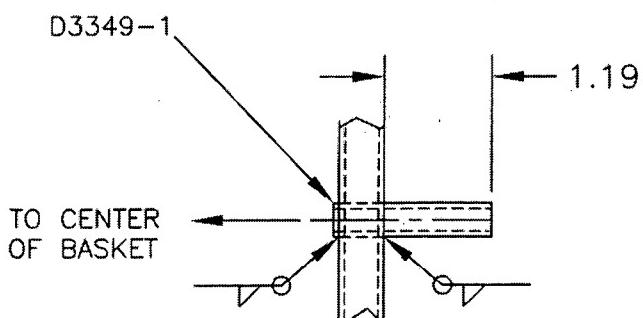
B	05.04.25	CHANGE RIVET AND HOLE DIAMETER		
A	04.10.21	NEW ISSUE		
DESIGN <i>SI</i>	DRAWN BY <i>SI</i>	<b>DART</b>	<b>DART AEROSPACE LTD.</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>SI</i>	APPROVED <i>SI</i>	DRAWING NO. D3325	REV. B SHEET 1 OF 3	
DATE 05.04.25	TITLE BASKET LID ASSEMBLY		SCALE 1:20	



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DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4



VIEW A-A



DETAIL D  
(SCALE 1:2)

RELEASED  
05-04-28

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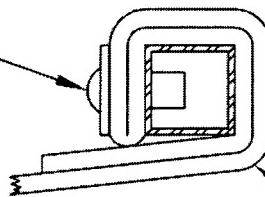
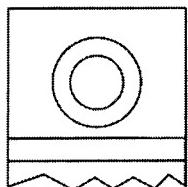
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CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3325	REV. B SHEET 3 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4

MS20600AD4W3 RIVET (1)  
AN960JD9 WASHER (1)

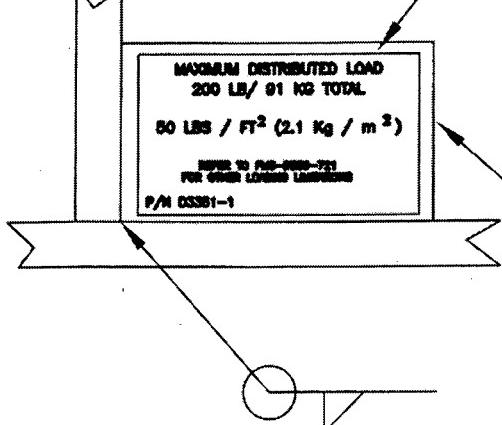


DETAIL B  
TYP. ATTACHMENT OF WEBBING TO LID  
FRAME  
(SCALE 1:1)

D3320-041 WEBBING

RELEASED  
05.04.28 *PH*

ATTACH D3351-1 PLACARD  
ON TOPSIDE OF D3352-1



D3352-1

OUTBOARD

DETAIL C  
LABEL PLATE ATTACHMENT  
(SCALE 1:2)

IDENTIFY WITH DART P/N  
D350-721-041 USING  
D2729-1 PRODUCT ID  
INSTALLED ON UNDERSIDE OF  
D3352-1

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WORK ORDER

NO. *41280A*

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